

Work Order ID ~~677487~~

77487

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December-08-11 1:40:10 PM

ASAP

Item ID: D3042-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clamp

Start Date: 08/12/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 15/12/2011 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: M.C.J

Date: 11/12/08 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3042

Rev A

100

0.00

100

PURCHASING

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg

304 . 063

Dwg Rev: A

Prog Rev: D

2-Debur if necessary

B11-12-9

45

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

Ensure Material Release Note is attached

B11-12-9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77487

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Item ID: D3042-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Clamp
 Start Date: 08/12/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 15/12/2011 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00		Switzler		counted (x45)			
130 *130* Brake NC Brake NC	Form as per dwg Small Fab Memo	0.00 0.00		Sw 11/12/12		(45)			
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		Sw 11/12/12		counted (x45)			

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 77487

77487

Parent Item: D3042-1

D3042-1

Parent Item Name: Clamp

Start Date: 08/12/2011

Required Date: 15/12/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP: C01.11.08Revised Step 5SM
11.03.17 now made in house DD verf:EC

IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S16GA

Purchased

No

100

sf

235.6000

0.03

1.263158

1.5

M304S16GA

**

B11-12-9

304/316 Sheet .063

Location

Loc Qty

Loc Code

MAT020

235.6

119653

235.6

119653

45

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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W/O:		WORK ORDER CHANGES					
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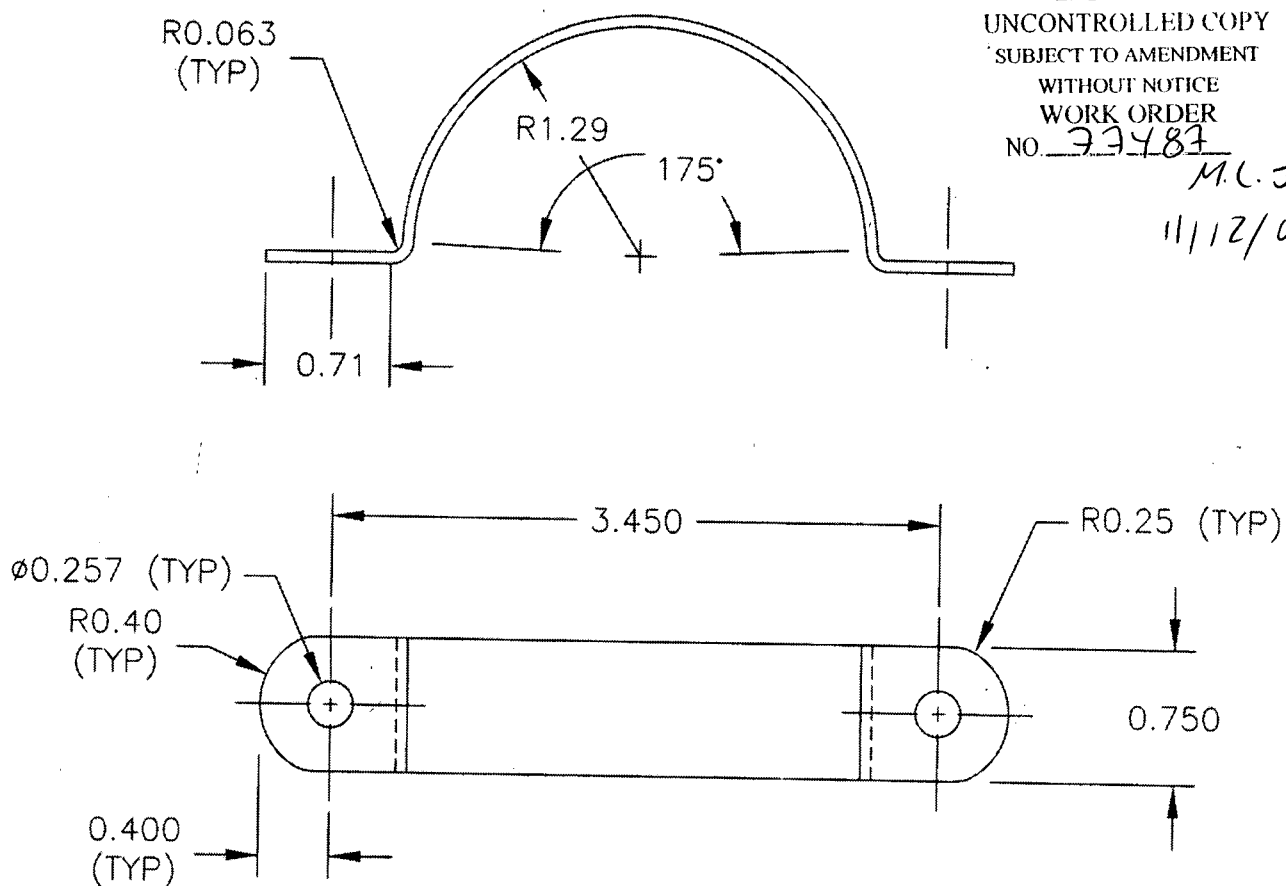


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3042	REV. A SHEET 1 OF 1
DATE 01.06.29		TITLE CLAMP	SCALE 1:1
A	01.06.29	NEW ISSUE	

RELEASED
01.07.09 *[Signature]*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 77487

M.C.J
11/12/08



D3042-1

- 1) MATERIAL: AISI 304/316 SS ANNEALED PER AMS 5513/5524
0.063 THICK
- 2) FLAT LENGTH: 5.713 END-TO-END
4.913 HOLE-TO-HOLE
- 3) BREAK ALL SHARP EDGES 0.005-0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 77495

77495

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Thursday, December 08, 2011 4:40:28 PM

Item ID: D3591-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 12/8/2011 Start Qty: 28.00 ***28*** Cust Item ID:
 Required Date: 12/9/2011 Req'd Qty: 28.00 ***28*** Customer:
 Reference: SCRAP

Approvals: Process Plan: mf Date: 11-12-08 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3591	Rev B

150 0.00
150
 Small Fab Memo 0.00
 Small Fab PULL FROM STOCK D3591-1 B 71847 X 28
 SCRAP PARTS

160 QC21- Final Inspection - Work Order Release 0.00
160
 QC Memo 0.00
 Quality Control

11/12/08

11/12/13

11.12.09

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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